

Work Order ID 79008

79008

Page 1

Wednesday, January 18, 2012 12:39:01 PM

Item ID: D3128-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 1/18/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 12-01-18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3128

Rev B

110

0.00

110

Waterjet

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

FLOW CNC Waterjet

CUT PER FILE AND DWG

PROG REV: B

DWG REV: D

DEBURR

B12-1-19

(6)

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

B12-1-19

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

8/26/19

6

6X4M/12/01/19

6 10/12/19

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 27

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/1/12

12/1/23

12-01-25

Picklist Print

Wednesday, January 18, 2012 12:39:00 P

Page 1

Work Order ID: 79008

Parent Item: D3128-1

Parent Item Name: Shim

Start Date: 1/18/2012

Required Date: 1/31/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A03.01.16New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.080 5052-H32 .080 Sheet		Purchased	No			100	sf	41.0000	0.0277	0.1749474			

1812-1-19

LocationLoc QtyLoc Code

MAT022

41

100742

35

100974

4

19729

2

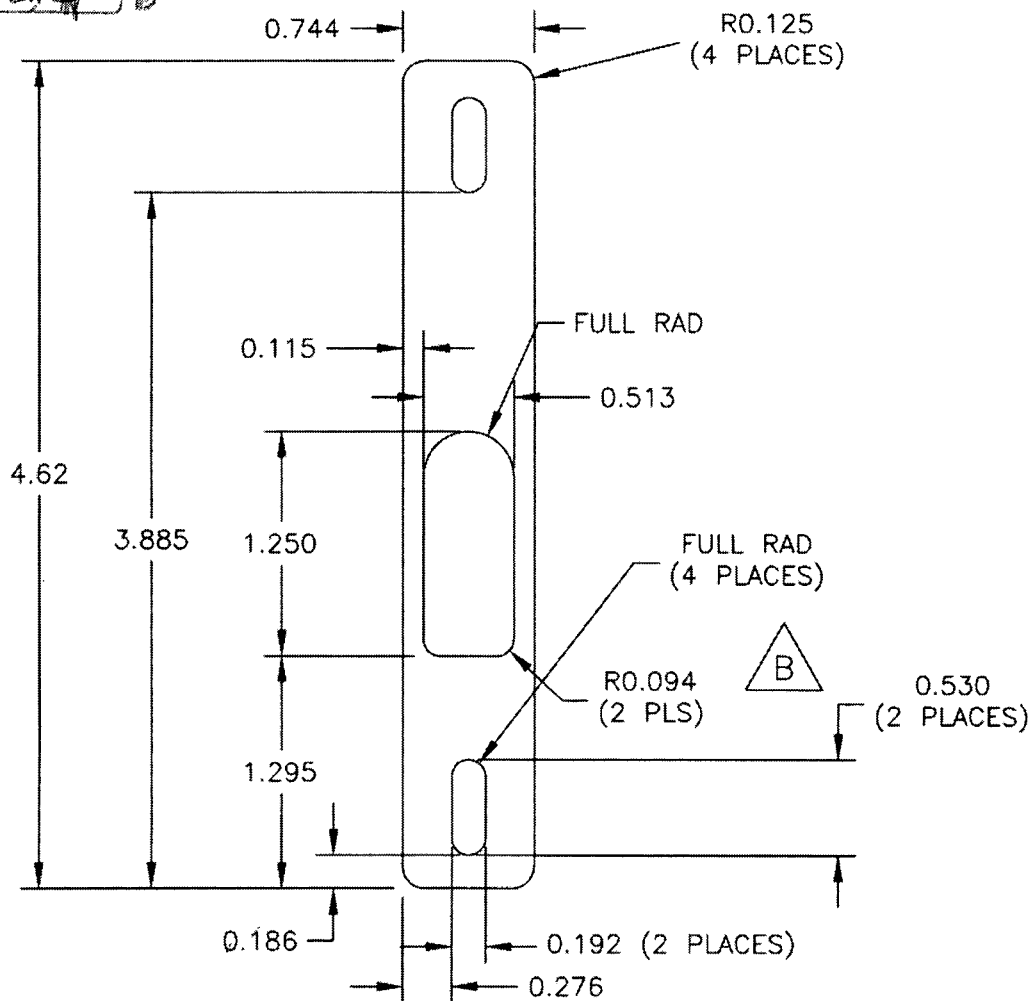
100742

(6)



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3128	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE SHIM	SCALE 1:1
A	02.04.18	NEW ISSUE	
B	04.10.18	ADD PART MARKING; ADD R0.094	

RELEASED
04.11.23



D3128-1 SHIM
REPLACES PREMIER P/N B30-23000-235

NOTES

- 1) MATERIAL: 5052-H32/H34 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11)
OR 2024-T3 (QQ-Q-250/4) 0.080" THICK
(REF DART SPEC 5052H32S.080 OR 6061T6S.080 OR 2024T3S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD		Work Order:	79008
Description: SHIM		Part Number:	D3128-1
Inspection Dwg: D3128-1		Rev:	B
			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

X	Prototype
1	1
2	2
3	3
4	4
5	5
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99	99
100	100

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.192	$\pm .010$.196	2		V	H302
.530	$\pm .010$.534	2		V	
.744	$\pm .010$.748	2		V	
.118	$\pm .010$.119	2		V	
1.250	$\pm .010$	1.256	2		V	
1.295	$\pm .010$	1.299	2		V	
.276	$\pm .010$.275	2		V	
.186	$\pm .010$.187	2		V	
3.885	$\pm .010$	3.889	2		V	
4.62	$\pm .010$	4.621	2		V	
.086	$\pm .010$.080	2		V	

Measured by: <u>B</u>	Audited by: <u>8</u>	Prototype Approval:
Date: <u>12-1-19</u>	Date: <u>12/1/19</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	